

Date: Wednesday, 9/13/2006 4:28:16 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206 A/B HIGH GEAR SKIDTUBE
<b>Job Number</b> : 28516	
<b>Estimate Number</b> : 10170	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D206642212
<b>This Issue</b> : 9/13/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> : 28514	<b>Material</b> : N/A
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 10/6/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>[Signature]</u>	
<b>Comment</b> : Est Rev:K 05.07.14 ECN 847 & 901; Add Tow Ring and GHW Kit KJ/CP/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL  
 Photocopy bluefile & type labels per PPP206-642-212 CHG004

KJ 06.09.19 ①

2.0	28516A	HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
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**Comment:** Sub-Component HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B  
 D206-642-241 B 28516A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Pick Packing Kit

4.0	D206651041	206 A/B GHW Kit
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 1 D206-651-041 GHW Kit 24197  
 ✓ 1 D206-642-241(REF) 1328516A

5.0	D2652	Bushing
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**Comment:** Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 16 D2652 Bushing 1328252

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 28516

Part Number: D206642212

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2655	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 1	D2655	Tow Ring	27110 -

7.0	D26652	Saddle, RH, Fwd,Aft, Out
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 2	D2665-2	Saddle	25980 -

8.0	D26662	Saddle, RH, Fwd,Aft, In
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 2	D2666-2	Saddle	27111 -

9.0	D2712	Set Screw
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 10	D2712	Set Screw	B26481

10.0	D2884	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 2	D2884	SADDLE SPACER	25982 1x B28259 ✓

11.0	D2885	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part Number	Description	Batch
✓	Saddle Spacer		B27969

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28516

Part Number: D206642212

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN3-41A

Bolt

M102335 7 X M102658 1X

13.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN4-5A

Bolt

M102887 -

14.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

M101418 -

15.0

AN57A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-7A

Bolt

M102140 -

16.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-11A

Bolt

M102407 -

17.0

AN644A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN6-44A

Bolt

M100447 -

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28516

Part Number: D206642212

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 8 AN960JD10

Washer M100743-

19.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 25 AN960JD416

Washer M102399-

20.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 8 AN960JD516

Washer M102328-

21.0

AN960JD616

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 4 AN960JD616

Washer M101124-

22.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 8 MS21042L3

Nut (or -3) - M101912-

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 05/11/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28516

Part Number: D206642212

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 12 MS21042L4 Nut (or -4) M19185 -

*P60*

24.0

MS21042L6

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

✓ 2 MS21042L6 Nut (or -6) M100151 -

*11/4/14 ①*

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*1306/11/14 ①*

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-212

Location: D

PPP Rev: D

*1306/11/14 ①*

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*1306/11/15 ①*

Job Completion



*1206-11-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B  
 Job Number : 28516A  
 Estimate Number : 10163  
 P.O. Number : N/A Part Number : D206642241  
 This Issue : 9/13/2006 S.O. No. : N/A Drawing Number : D2650 REV E P1,3  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E  
 Previous Run : 28514A Material : N/A  
 Due Date : 10/6/2006 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : KJ 06 09 14  
 Comment : Est Rev: M 04.12.02 Revised procedural steps KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D206-642-241 CHG003 N/A

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2620 Bent Tube 3" OD B28457 DP 6-9-19

3.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3286-1 Doubler B27594 BE 6-10-06

4.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2647 Fwd Cap B24842 BE 06 09 19

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube DP 6-9-19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28516A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

DP 6-9-19

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod m/01010 / m/01655 BE 06-09-19

4-Grind weld flush to cap on top surface only.

Pmc 06-9-2001

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

Pmc 06-9-2001

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

DP 6-9-28

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

BE 06-10-06

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time

BE 06-10-06

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

BE 06-10-06

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

BE 06-10-06

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

BE 06-10-06

14-Remove indexing edge using DT8741 as per Dwg D2650

BE 06-10-11

15-C'sink GHW rivet holes as per Dwg D2650

BE 06-10-11

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-10-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28516A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

*3 BE*  
*06-10-18*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M-R 06/10/19*

*①*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Pm 06-10-23 ①*

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

*Pm 06-10-23 ①*  
*Pm 06-10-23 ①*  
*Pm 06-10-23 ①*

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*06-10-23 ①*

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

*m102049*

*Pm 06-10-23*

*⑤2* *71 Pm*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 28516A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2654-3

Web

324008

Pm' 06-10-23 (1)

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

Pm' 06-10-23 (1)

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Pm' 06-10-23 (1)

Start Date: 06-10-23

Time: 11:15am

Finish Date: 06-10-24

Time: 1:30pm

Pick:

Qty Part Number

Description Batch

A/R Sikaflex-291

m162107

Sikaflex expire date:

07-02-01

Pm' 06-10-23 (1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-10-24

16.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

18 -D2649

Crossbolt spacer

B28250 BE 06-10-24

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3286-3

Spacer

B24711 BE 06-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28516A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M101010 ~~BE~~ 06-10-24 (1)

2-Grind welds flush as per Dwg D2650.

Pm' 06-10-25 (1)

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R SS Rod

NONE USED

BE 06-10-26 (1)

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

Pm' 06-10-27 (1)

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

M101938 Pm' 06-10-27 (2)

20.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets

M19099 Pm' 06-10-27 (2)

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041

Nut Plate

B24203 Pm' 06-10-27 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28516A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*Pm '06-10-27 (1)*

Install D2680-041 Nut Plate as per Dwg D2650

23.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

*M06/10/30*

24.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

*yl 06/11/06 x1*

*M101575*

25.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 06 11 07*

26.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2648-3	Wearpad	<i>27169</i>

27.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearshoe	<i>27739</i>

28.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-21	Wearshoe	<i>27075</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:29:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28516A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

20213

30.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

~~22121~~ 29201

31.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130 Inserts

18990

or (see QSI 017)

32.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 AN960JD10L

Washer

100233

33.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS27039-1-08

Screw

102404

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 9/13/2006 4:29:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28516A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2651-1 Plugs 28691

35.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2651-3 O-Rings 28901

36.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw 6874

37.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer 1151

38.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 102107

Sikaflex expire date: 02/07

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:29:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28516A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646

Aft Cap

28041

40.0

MS27039108,

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw

102404

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer

100233

42.0

HAND FINISHING1:

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

102107  
02/07

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch:

102098

} -yl 06/10/07  
yl 06/11/08

43.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

DL 06/11/08 ①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 9/13/2006 4:29:25 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 28516A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206664241 IF APPLICABLE

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

N/A

45.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

206 11/15

Job Completion



U. 06/14/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>14/</i>	DRAWN BY <i>10</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES SCALE NTS	
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED  
16 04 17 *H*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

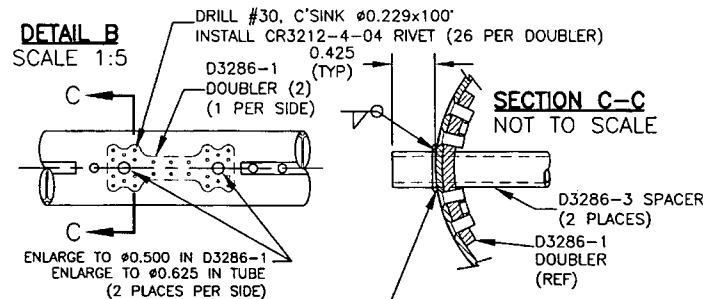
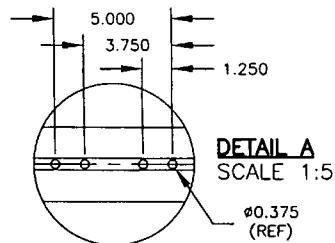
**NOTES**

- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

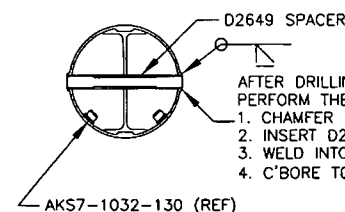
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**SECTION C-C**  
NOT TO SCALE

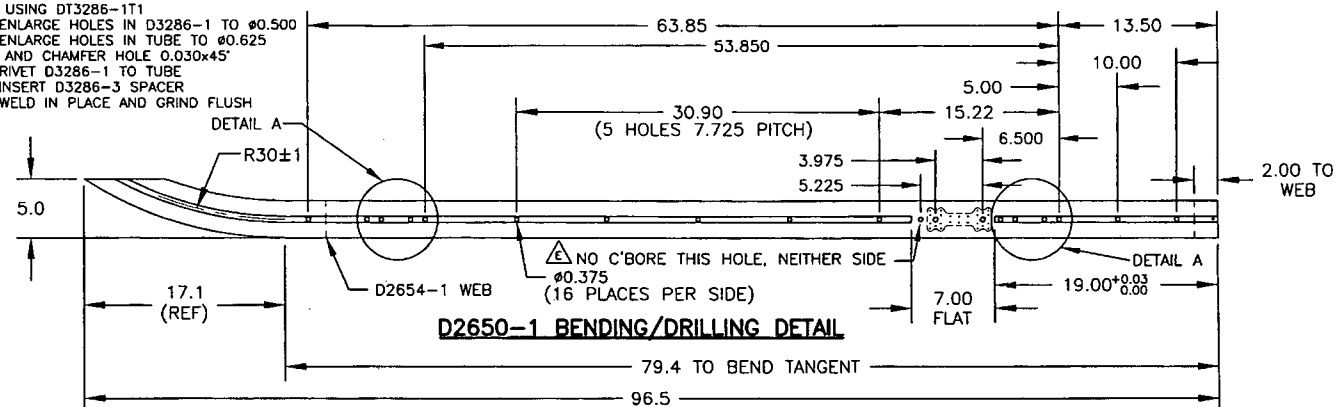
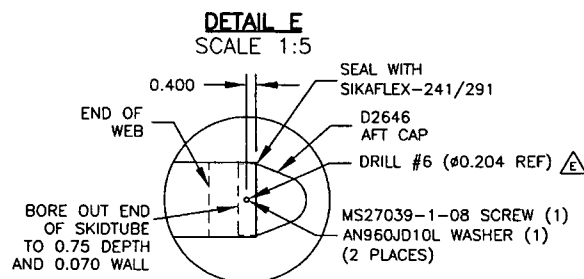


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313 X 0.75 DEEP

RELEASED

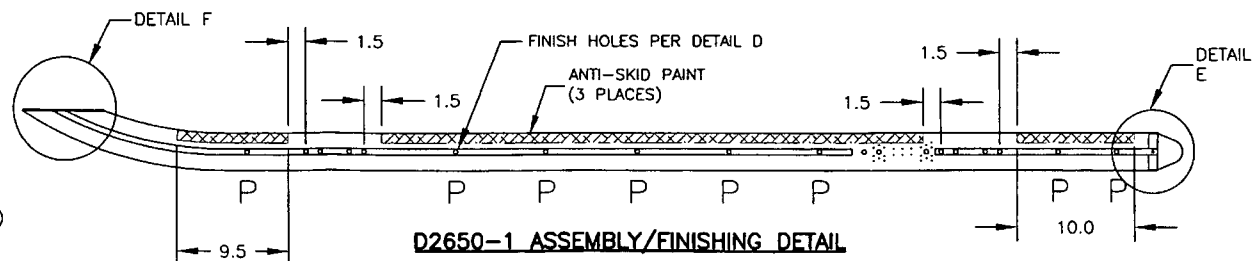
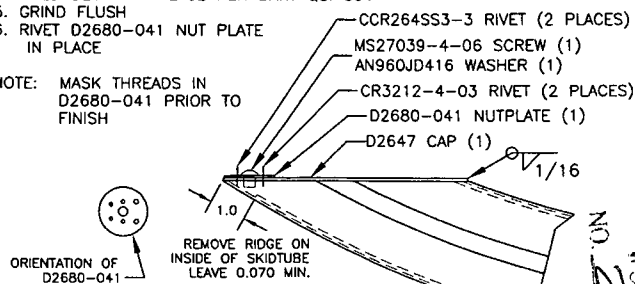
06.04.17



**DETAIL F (NOT TO SCALE)**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



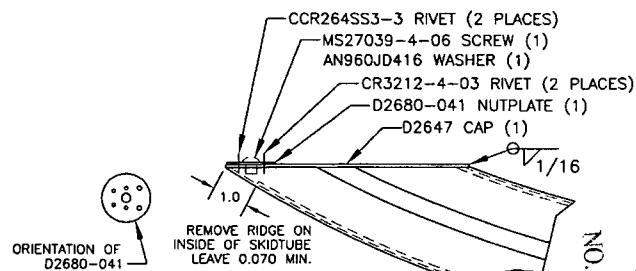
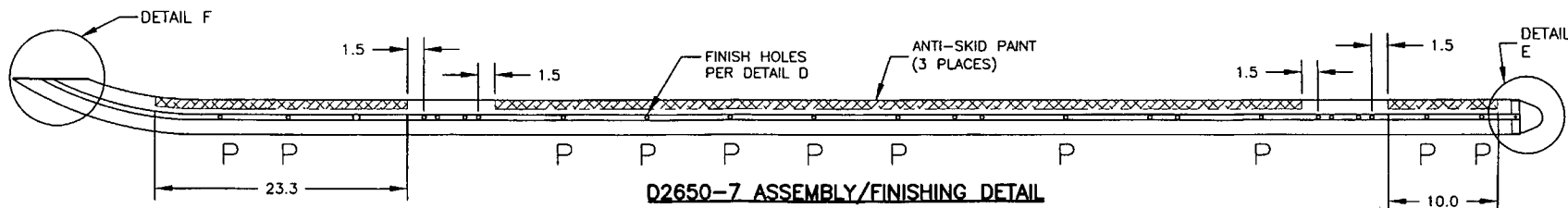
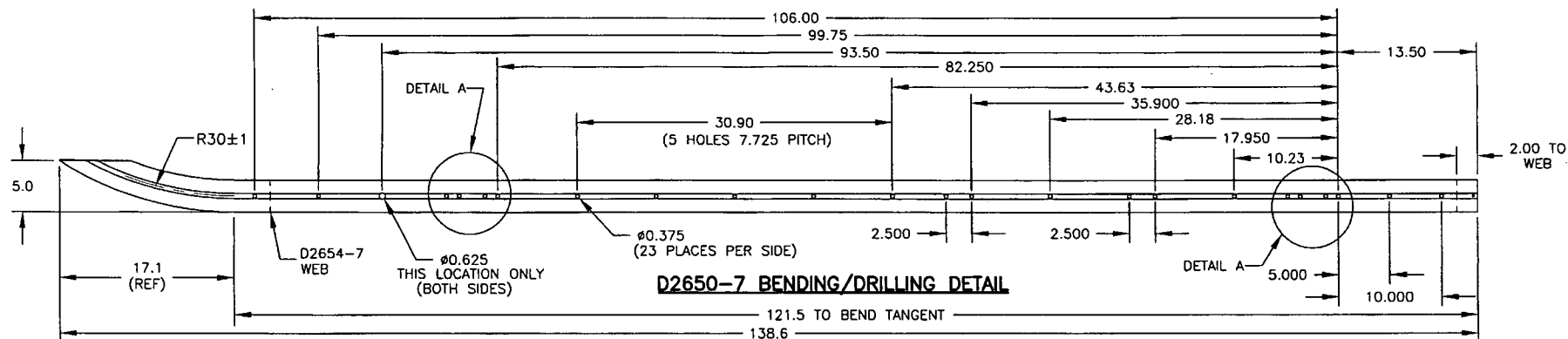
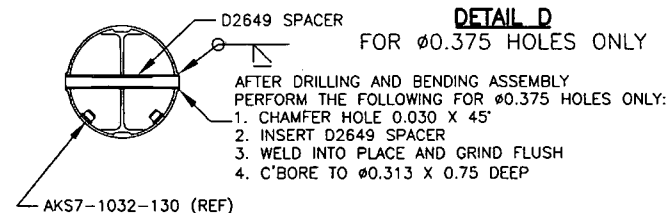
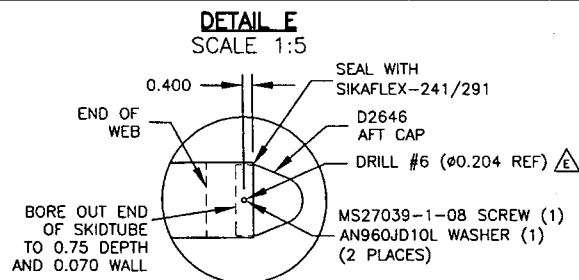
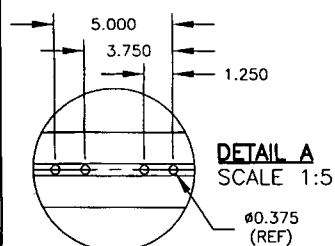
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		DATE	06.03.30			D2650	SHEET 2 OF 5
						SKIDTUBE	SCALE 1:10

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PH		D2650	SHEET 4 OF 5
DATE	TITLE		SCALE
06.03.30	SKIDTUBE		1:10



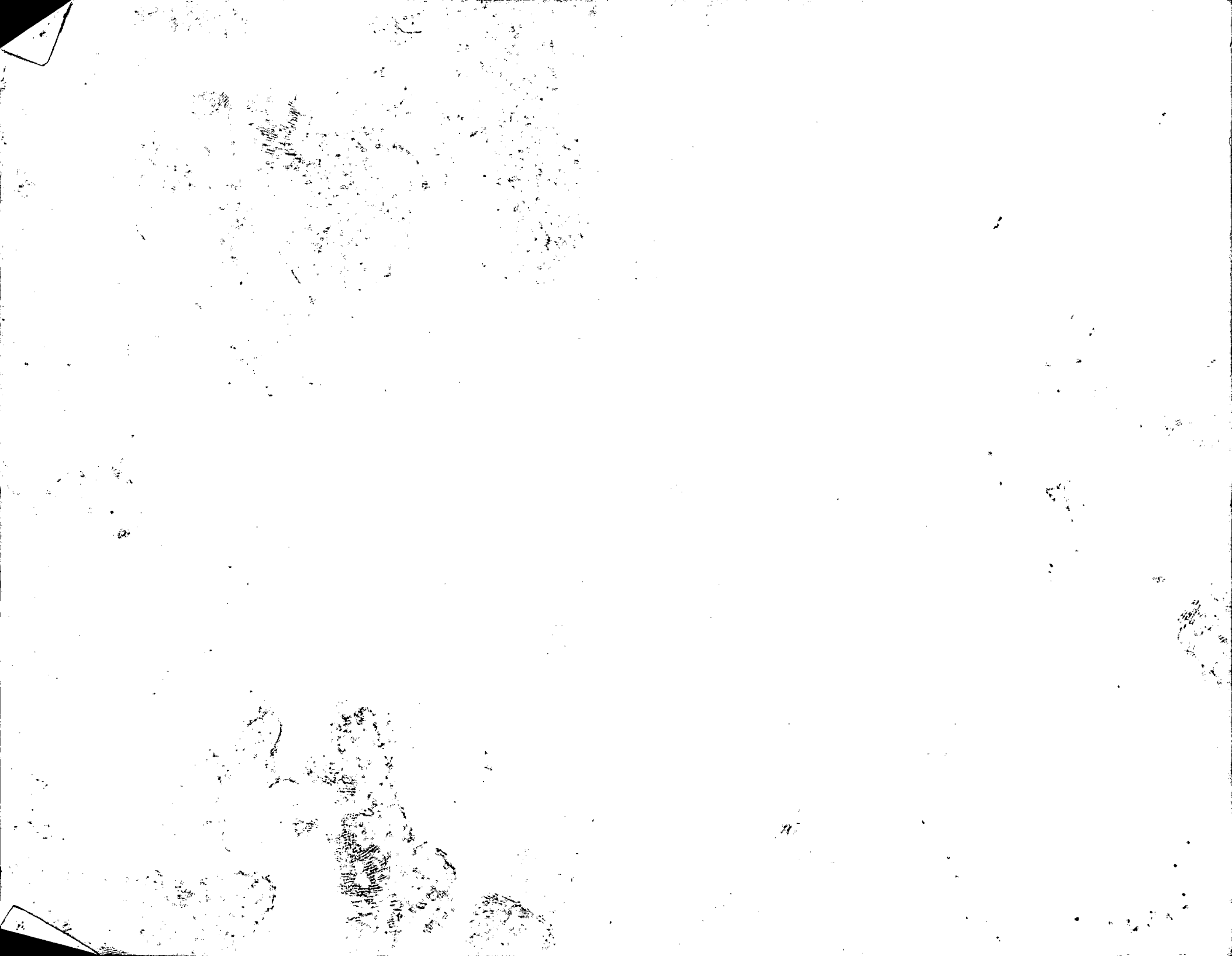
- DETAIL F (NOT TO SCALE)**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

WORK ORDER NO. 28516A  
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		DATE	06.03.30			TITLE SKIDTUBE	SCALE 1:10

RELEASED  
 a.v.n. #



NO. 38

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number A206642241 / B28/SSA

TEST WELDS REQUIRED

BASE METAL	<u>Alum</u>	WELDING PROCESS	<u>Tig</u>
Penetration	Complete [ ] Partial [ <input checked="" type="checkbox"/> ]	Single Weld [ <input checked="" type="checkbox"/> ] Double Weld [ ]	
Current	AC [ <input checked="" type="checkbox"/> ] DC [ ]	Backing	YES [ ] NO [ <input checked="" type="checkbox"/> ]
	Position	Vertical	Down [ ] Up [ ]
Sheet Groove	1G [ ]	2G [ ]	3G [ ] 4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ] 6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ] 4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ] 5F [ ]
Crossbolt Spacer	Welded into		Skidtube

TEST RESULTS

Visual Pass [ ☒ ] Fail [ ]  
Penetration Pass [ ☒ ] Fail [ ]  
Crossbolt Spacer Pass [ ☒ ] Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/23

Qualifier Daniel Suval